

**Abstract**

Battery cans are produced by a group of drawing press tools and merged into a single line of sequential intermediate operations, including a washer/dryer operation and a coating operation. The merge and washer/dryer speeds are established by the fastest drawing press speed. A variable capacity buffer between the washer/dryer and coating line adjusts for temporary overproduction or underproduction of the washer/dryer and sets the speed of the coating line downstream.